



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2858-2
Job Sheet 176059



Part No: D2858-2

Job Qty: 21 ea

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		4/28/18	0.00	0.00	Start Up Machining-1		K+ 2018-04-18
100	Bandsaw	20 pcs		4/28/18	0.00	0.06	Bandsaw1		K+ 2018-04-18
110	CNC Vertical Machining	20 pcs		4/28/18	0.00	5.49	HAAS1-2		K+ 2018-04-18
130	QC	20 pcs		4/28/18	0.00	0.00	QC8 Machining-1		2x, 8/04/20
140	HandFinish	20 pcs		4/28/18	0.00	0.39	HandFinish1		SA 18-04-23
150	Powdercoat	20 pcs		4/30/18	0.00	0.34	Powdercoat1		BA 18-4-24
160	QC	20 pcs		4/30/18	0.00	0.00	QC3		DAS 11 APR 24 2018
170	Packaging	20 pcs		4/30/18	0.00	0.00	Packaging3-1	stop	APR 25 2018
180	QC21-SA	20 Ea		4/30/18	0.00	0.00	QC21	9-8g	

Part Op 110 - 1-Machine per folio FA941

Descriptions: 150 - START TIME: 8:40 O.V.T. 320° FINISH 9:10. M/B 760.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X01.250	6061-T6 Bar 1.50 X 1.25	3.2600 ft (.163 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X01.250	3	14	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.171inches + 0.005 - 0.000	0.176 0.171		
2	Hinge Bracket	0.400inches + 0.005 - 0.000	0.405 0.400		
3	Hinge Bracket	0.125inches ± 0.010	0.135 0.115		
4	Hinge Bracket	0.328inches ± 0.010	0.338 0.318		
5	Hinge Bracket	0.820inches ± 0.010	0.830 0.810		
6	Hinge Bracket	1.476inches ± 0.010	1.486		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐																																																							
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Descripti 1610 Avenue, Ouellet Newbury, ON K8A 1K7 CANADA TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com UAKI AEROSPACE Container No: S062594 Part: D2858-2 Job No: 176059 Serial No/Batch: S062594 Revision: _____ Inspector: _____ Date: 04/18/18		Completed By _____																																																																								
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			1.466
7	Hinge Bracket	0.342inches $\pm$ 0.010	0.352 0.332
8	Hinge Bracket	0.875inches $\pm$ 0.010	0.885 0.865
9	Hinge Bracket	1.560inches $\pm$ 0.030	1.590 1.530
10	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137
11	Hinge Bracket	0.717inches $\pm$ 0.010	0.727 0.707
12	Hinge Bracket	0.697inches $\pm$ 0.010	0.707 0.687
13	Hinge Bracket	0.229inches $\pm$ 0.010	0.239 0.219
14	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115
15	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053
16	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053
17	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116
18	Hinge Bracket	0.630inches $\pm$ 0.010	0.640 0.620
19	Hinge Bracket	0.354inches $\pm$ 0.010	0.364 0.344
20	Hinge Bracket	0.965inches $\pm$ 0.010	0.975 0.955
21	Hinge Bracket	0.166inches $\pm$ 0.005 - 0.000	0.171 0.166

Plex 4/16/18 11:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					